



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-113

Job Sheet 190059

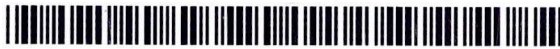


DAS
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9-89

Part No: D350-591-113

Job Qty: 10 pcs

Part Name: Heli-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description: AIRBUS

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586
10.06.18 DD verf:EC

Ship Via:

UNDER REVIEW

SAN 19-04/16

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	5/3/19		0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
115	QC 5	10 pcs	5/3/19		0.00	0.00	Large Fab - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		

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				QC 9 - 9		
				QC 5 - 50		
				QC 5 - 30		
120	Conventional Mill - 1 - B4B	10 pcs	5/3/19	0.00 0.00	Conventional Mill - 1 - B4B	<i>11</i>
125	QC 2	10 pcs	5/3/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	<i>11/19/4/12</i>
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
130	QC 8	10 pcs	5/3/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	<i>11/19-04-12</i>
					QC 8 - 47	
					QC 8 - 40	
135	Large Fab - Welded Assy-2-	10	5/3/19	0.00 0.00	Large Fab - 2 - B4B	DAS 24 APR 17 2019
						<i>Plex 3/5/19 9:06 AM dart.tsimiklis.chrisoula</i>

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B4B		pcs				
140 QC 5	10 pcs	5/3/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	DAS
					QC 5 - 49	43
					QC 5 - 51	9-89
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150 QC 9	10 pcs	5/3/19	0.00	0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	DAS
					QC 9 - 50	43
					QC 9 - 9	9-89
165 Handfinish - 1-1 Chemical-B4B	10 pcs	5/3/19	0.00	2.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR19/04/17
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170 Large Fab - Steps - 2 - B4B	10 pcs	5/3/19	0.00	10.32	Large Fab - 1 - B4B	

						Large Fab - 10 - B4B	
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	DAS
						Large Fab - 6 - B4B	43
						Large Fab - 7 - B4B	9-89
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
180 QC 10	10 pcs	5/3/19	0.00	0.00		QC 10 - 10	
						QC 10 - 18	DAS
						QC 10 - 24	24
						QC 10 - 38	9-89
						QC 10 - 43	
						QC 10 - 50	
						QC 10 - 58	
						QC 10 - 9	
						QC 5 - 10	
						QC 5 - 12	
190 QC 5	10 pcs	5/3/19	0.00	0.00		QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	DAS
						QC 5 - 24	24
						QC 5 - 3	9-89
						QC 5 - 38	
						QC 5 - 42	
						QC 5 - 43	
						QC 5 - 49	
200 Handfinish - 1-2- Chemical- B4B	10 pcs	5/3/19	0.00	2.22		QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	D.R19/05/02
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	

						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
210 Powdercoat - 1 White GI(A)- B4B	10 pcs	5/3/19	0.00	2.06		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	10 pcs	5/3/19	0.00	2.22		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
230 QC 3	10 pcs	5/3/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 26	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 38	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 6	
						QC 3 - 68	
						QC 3 - 9	
240 Packaging 1-1 - Pick Kit - B4B	10 pcs	5/3/19	0.00	0.00		Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	

210 Powdercoat - 1 White GI(A)- B4B *M15744*
START: 8:00 AM T: 3:30 PM FINISH: 8:30

B#19-5-2
W19-5-3

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					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
250	QC 4	10 pcs	5/3/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
255	DC - 1 - B4B	10 pcs	5/3/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
260	Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

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				Packaging 3 - 35 - B4B		
270 QC 21 - FG	10	5/3/19	0.00	0.00	QC 21 - FG - 21	21
	pcs				QC 21 - FG - 70	21
					QC 21 - SA - 53	21

MAY 08 2019

Part Op 110 - (Fabricate per Drwg) 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310
Descriptions: using drill Jig DT8230

115 -

120 - 1- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.

135 - 1- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: 4/30/13 2- Grind end cap and bottom bushing welds flush 3- Machine top weld on bushing flush as per dwg.

140 - (QC5- Inspect part completeness to step on W/O)

165 - (Chemical Conversion Coat per QSI005 4.1)

170 - (Weld per dwg A/R Aluminum rod Batch: 4/30/13) 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: 4/30/13 4-Grind end cap welds flush

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Chemical Conversion Coat per QSI005 4.1)

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

220 - (Wing Walk as per dwg QSI005 4.4 Batch _____) ***Install Dart labels after wing walk***

230 - (QC3- Inspect Part Finish) ***Install Dart labels after wing walk***

240 - (Pick Kit)

250 - (QC4- 100% Inspect kits for completeness)

255 - (Document Control) Photocopy bluefile & type labels per PPP D350-591-113 CHG005

260 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D350-591-113

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
✓ D2244-116	Step Extrusion	10 pcs (1 ea)	110-Large Fab - Steps - 1	164533
✓ D2275	Bushing	10 pcs (1 ea)	110-Large Fab - Steps - 1	5016564 → 2 5158848 → 8
✓ D2673-34	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5149847
✓ D2582	Hi-Skid Step Leg Assembly	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	5176262 → 7 5153404
✓ D2673-34	End Plate	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	5149847
✓ MS20600-AD4W3	Cherry Rivet	160 Ea (16 ea)	170-Large Fab - Steps - 2 - B4B	5155768
✓ K591-113	Short Step Installation	10 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	5166854

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	10	93	0
	D2275	10	14	0
	D2673-34	20	24	0
170-Large Fab - Steps - 2 - B4B	D2582	10	10	0
	D2673-34	10	24	0
	MS20600-AD4W3	160	701	0
240-Packaging 1-1 - Pick Kit - B4B	K591-113	10	2	0

Part Specifications

Specifications could not be found.

Plex 3/5/19 9:06 AM dart.tsimiklis.chrisoula

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JE COLLECTIONS PUNTA CANA

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S159577



Part: D350-591-113

Job No: 190059

Serial No/Batch: S159577

Revision:

Inspector:

Exp Date:

Instructions:

Date: 03/06/19

Under Review Notification

Raised By: Steven Drouin

Product #: D350-591

Date: 19.03.13

Product Name: HELI-ACCESS-STEP

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN / URF Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		DO NOT SHIP	Red Tag/Quarantine Stock	Advise Customers	Hold all Production	Re-Work Stock	IPP Under Review (Engineer Signoff Required.)	Put Product Specifications Under Review ("Bluefiles")		
D350-591-113	IIN-D350-591 Rev.I	Y	Y	N	Y	N	Y	Y	19-637	CHG#005
D350-591-117A	IIN-D350-591 Rev.I	Y	Y	N	Y	N	Y	Y	19-637	CHG#003 ~ 1 SHL F9010
D350-591-119	IIN-D350-591 Rev.1	Y	Y	N	Y	N	Y	Y	19-637	CHG#004 - 10 WIP COND.
D2362	D2362 Rev.E1	Y	Y	N	Y	Y	Y	Y	19-637	Drawing update
D2275	D2275 Rev. C	Y	Y	N	Y	Y	Y	Y	19-637	Drawing update

Description of Issue:

D2362 SLOT DIMENSION ON STEP SUPPORT BRACKET NEEDS TO BE MOVED BY 0.060
D2275 NEEDS TO REDUCE CHAMFER ON BUSHING
D350-591-113 HOLE DIMENSION FOR BUSHING NEEDS TO BE REVIEWED

PLEASE SEE ENGINEERING FOR MORE DETAILS
REF:CAR19-305

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Marketing Eugene

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D2362-3 x 10 ST537
- 7 x 2 ST537

